










Wednesday, 8/15/2007 3:13:55 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)
Job Number	: 33906		
Estimate Number	: 11000		
P.O. Number	: <i>N/A</i>	Part Number	: D26021
This Issue	: 8/15/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2602 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 32819	Material	: <i>N/A</i>
Written By	: <i>JLM/07-08</i>	Due Date	: 8/31/2007 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est. D 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-2 Est Rev:E Now On Waterjet 07-03-22 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
			
Comment: Qty.: 1.4146 sf(s)/Unit Total : 28.2912 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>M105225 1B07-08-15</i> <i>↳ 20 scrap</i>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg Rev: <i>A1</i> Prog Rev: <i>A1</i> <i>1B07-08-15</i> 2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <i>En 07/08/20</i> <i>✓ 20</i> <i>count</i>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2602-1 PAR #: NA Fault Category: Prod / FAB ASS ^{med & small} NCR: (Yes) No DQA: LD Date: 07/08/16
 QA: N/C Closed: LD Date: 07/08/31

NCR: <u>33906</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/16	4	20 parts scrap due to wrong grain direction	<i>[Signature]</i>	Scrap and Destroy and Replace 2024-T3040" B# M105225	SAD 07/08/16	<i>[Signature]</i> 07/08/20	<i>[Signature]</i>	En 07/08/16
	1	R.C. operator did not know grain direction also was not on FB w/o of Drawing	<i>[Signature]</i>	update Drawing to specify grain direction	07/08/16	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 33906

Part Number: D26021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

ml 07/08/27 (20)

FB 07/08/29 (23)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 01/08/29

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

gl

07-08-31

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/08/31 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57/75

07/08/31

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/31 (20)

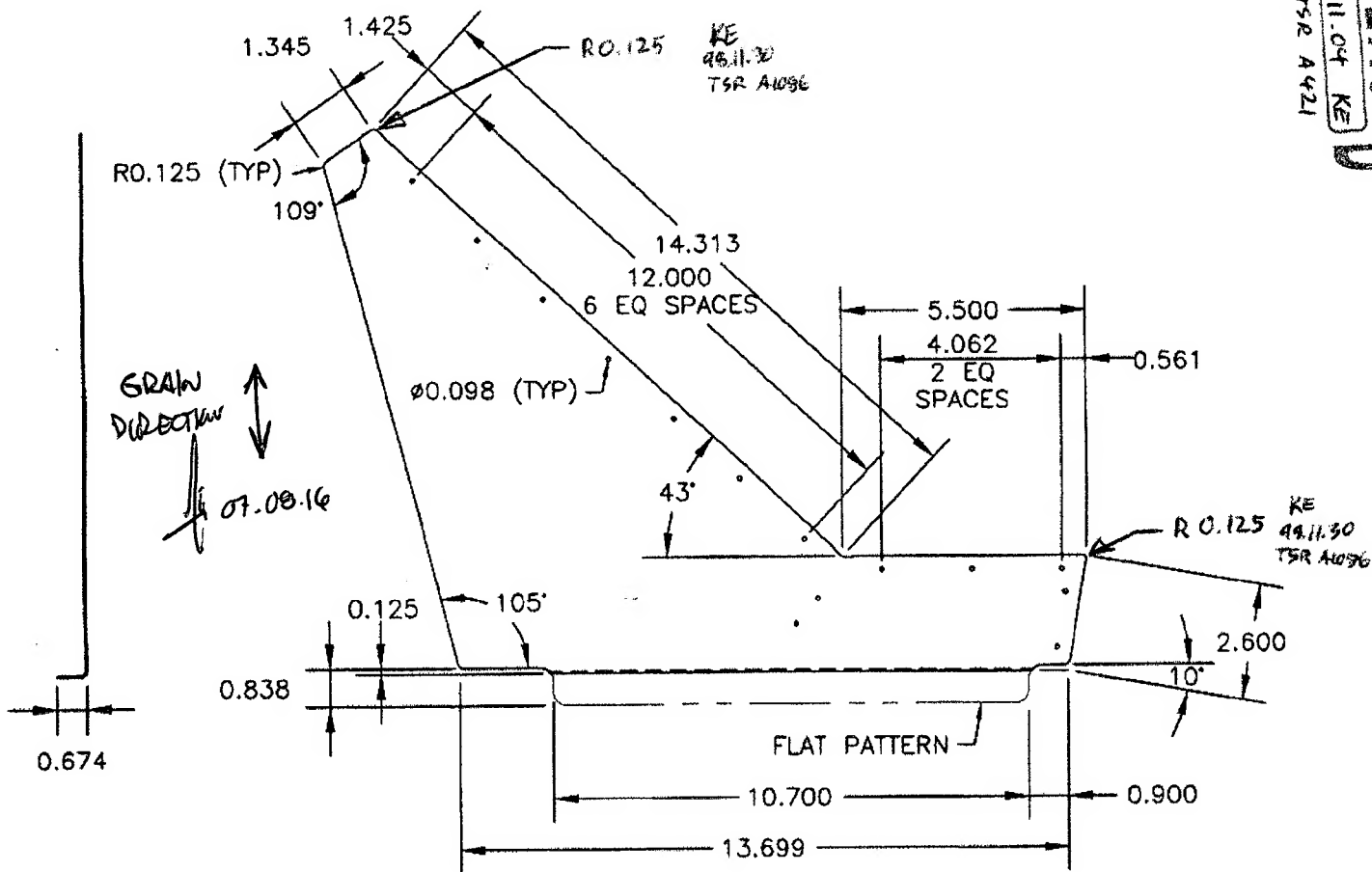
Job Completion




07/08/31

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
KE	SA	D2602	SHEET 1 OF 1
DATE	TITLE		
97.10.22	CONSOLE SIDE		
A	97.10.22	D2602 WAS 0206-547-21/ -22	
A1	02.06.04	ADD FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
 PROFILE CONTROLLED BY FOLIO H2602
 BEND RADIUS 0.093
 FINISH: CHEMICAL CONVERSION COAT PER PART QSI 605 4:1 
D2602-1 SHOWN
D2602-2 OPPOSITE